

ship 28/08 - 31/08

SPUR

Work Order ID 51549 -1

August 25, 2009 2:01:30 PM



Item ID: DSI 9464-011

Accept



Setup Start



Revision ID: A

Stop



Item Name: Skidtube Tuning

Start Date: 8/26/09 Start Qty: 5.00

6 u



Cust Item ID:

Required Date: 8/28/09 Req'd Qty: 5.00



Customer:

Reference:

Approvals: Process Plan: *BJ*

Date: 09-8-25

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3955

A

DSI 9464

A

100

0.00



DC

Document Control

Memo

Photocopy bluefile & type labels per PPP DSI 9464-011
C11G001

0.00

8 08/08/26

110

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

10/8/26

Work Order ID 51549

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Page 2

Item ID: DSI 9464-011

Accept



Setup Start



Revision ID: A

Stop



Item Name: Skidtube Tuning

Start Date: 8/26/09 Start Qty: 5.00



Cust Item ID:

Required Date: 8/28/09 Req'd Qty: 5.00



Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC4- 100% Inspect kits for completeness

0.00

2) 8/26/08



QC

Memo

0.00

Quality Control

130

0.00



Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP DSI 9464-011

Location:

PPP rev: DMBT

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/28/08 (4)
09/28/31
mr 09-08-31

Picklist Print

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Page 1

Work Order ID: 51549

Parent Item: DSI 9464-011RevA

Parent Item Name: Skidtube Tuning

Comments:

Start Date: 8/26/09

Required Date: 8/28/09

Start Qty: 5.00

Required Qty: 5.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D3955-041RevA 2x Manufactured No



Doubler Assembly

Warehouse Loc Qty Loc Code

Location

Main Warehouse

FG

50862

110

Each

4.0000

10.0000

12



→ 51580 4x Pcg/8/28 (4)

→ 51555 4x

→ 50862 4x

D3955-3RevA 2x Manufactured No



Cover Plate

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

50865

110

Each

4.0000

10.0000

12



→ B51579 4x Pcg/8/28 (4)

→ 51552 4x

→ 50865 4x

D3955-5RevA 2x Manufactured No



Plate

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

50866

110

Each

0.0000

30.0000

36



→ B51578 5x Pcg/8/28 (4)

→ 51551 3x

→ 50866 4x

D3955-7RevA 6x Manufactured No



Plate

B51719 3x Pcg/8/28

B51550 13x

B51577 28x Pcg/8/28

(43)

Picklist Print

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Page 2

Work Order ID: 51549

Parent Item: DSI 9464-011 RevA

Parent Item Name: Skidtube Tuning

Comments:

Start Date: 8/26/09

Required Date: 8/28/09

Start Qty: 5.00

Required Qty: 5.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3955-21 RevA 2P Gasket		Manufactured	No			110	Each	6.0000	40.0000 12 ✓			

Warehouse	Location	Loc Qty	Loc Code
Main Warehouse	ST	6	
	50863	6	

→ 51554 64
50863 6x

Rec'd 8/26 (6)

D3955-23 RevA 2P Template		Manufactured	No			110	Each	2.0000	40.0000 12			
------------------------------	--	--------------	----	--	--	-----	------	--------	------------	--	--	--

Warehouse	Location	Loc Qty	Loc Code
Main Warehouse	ST	2	
	50864	2	

→ B51586 1x
→ 51553 9x
50864 2x

Rec'd 8/26 (6)

CR3212-4-04 38x Cherry Rivet		Purchased	No			110	Each	786.0000	40.0000 28 ✓			
---------------------------------	--	-----------	----	--	--	-----	------	----------	--------------	--	--	--

Warehouse	Location	Loc Qty	Loc Code
Main Warehouse	ST	786	
	109297	26	
	109740	16	
	110153	6	
	111127	238	
	112314	500	

→ m111127 160x
m112314 68x

Rec'd 8/26 (6)

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Shop Packet Print

Page 2

Picklist Print

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Page 3

Work Order ID: 51549

Parent Item: DSI 9464-011RevA

Parent Item Name: Skidtube Tuning

Comments:

Start Date: 8/26/09

Required Date: 8/28/09

Start Qty: 5.00

Required Qty: 5.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

AN3-5A 4x



Bolt

Purchased

No

110

Each

2,515.000

20.0000



4 ✓

PC 9/1/06 (6)

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

2515

100188

212

105057

2245

15205

58

15205

AN3-6A 4x



Bolt

Purchased

No

110

Each

73.0000

20.0000



24

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

73

106662

22

107959

15

109752

29

112082

7

m112013 16x PC 9/1/06 (4)

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Shop Packet Print

Page 3

Picklist Print

August 25, 2009 2:01:29 PM

Page 4

Work Order ID: 51549

Parent Item: DSI 9464-011RevA

Parent Item Name: Skidtube Tuning

Comments:

Start Date: 8/26/09

Required Date: 8/28/09

Start Qty: 5000 6

Required Qty: 5000 6

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

AN3-7A 64



Bolt

Purchased

No

110

Each

126.0000

20.0000

24 ✓

PC 9/8/26 6

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

126

110704

26

111127

100

→ M110704

AN3-10A 64



Bolt

Purchased

No

110

Each

103.0000

20.0000

24 ✓

PC 9/8/26 6

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

103

111119

100

17566

3

→ M111119 214
→ M17566 34

NAS1149D0332J 64



Washer

Purchased

No

110

Each

200.0000

30.0000

36 ✓

PC 9/8/26 6

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

200

110625

16

110844

184

→ M110844

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Shop Packet Print

Page 4

Picklist Print

August 25, 2009 2:01:29 PM

Work Order ID: 51549

Parent Item: DSI 9464-011RevA

Parent Item Name: Skidtube Tuning

Comments:

Start Date: 8/26/09

Required Date: 8/28/09

Start Qty: 5.00

Required Qty: 5.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

MS210421.3

Purchased

No

110

Each

3,889.000

120000



Nut

8/28/09

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

3889

110844

32

111274

365

111668

992

112314

2000

112385

500

1111274

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS D205-634 REV. F OR EARLIER
AND INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D205-634 REV. 3 OR EARLIER

REF CANADIAN STC: SH96-88
REF FAA STC: SR00563NY
REF EASA STC: EASA.IM.R.S.01303

Purpose:

The Purpose of the DSI 9464-011 Kit is to allow operators to tune landing gear utilizing D205-634-041 skid tubes in order to eliminate vibration. This kit consist of various weights that can be attached to the fwd cap of the Dart skid tube.

Procedure:

Note: Installer must be careful not to damage underlying skid tube during drilling operations.

- 1) Locate D3955-23 template on the fwd cap of the skid tube. Transfer drill 19 x Ø0.098" holes from the D3955-23 template to the skid tube cap using a #30 drill.
- 2) Transfer drill 1 x Ø0.625" (15.8 mm) from the D3955-23 template to the skid tube as shown in Figure 1.
- 3) Transfer drill 1 x Ø0.201 (#7 drill) from the D3955-23 template to the skid tube as shown in Figure 1.
- 4) Deburr the drilled holes in fwd cap. Ensure the top surface of the cap is clear of debris.
- 5) Apply a layer of Sikaflex-241/-291 or Proseal 890 or MIL-S-8802 Class B2 sealant between the D3955-041 Doubler and the existing skid tube cap. Install D3955-041 Doubler Assy. using 19 x CR3212-4-04 rivets as shown in Figure 1. The nutplate in the D3955-041 Doubler Assy should pass thru the Ø0.625 hole in the cap.
- 6) Install tuning plates as shown in Figure 2. Torque AN3 bolts 15-25 in-lb (1.7-2.8 N-m). Test the landing gear for vibration.
- 7) If vibration persists, repeat step 6 until vibration is eliminated.
- 8) Update Weight & Balance as outlined below.

Weight And Balance:




The weight and balance increase associated with the installation of the DSI 9464-011 kit will depend on the number of plates that are installed to tune the gear. Plates must be installed symmetrically. The weight of individual plates are given in the Part List Table. The longitudinal arm for the installation of the DSI 9464-011 kit is 40.0 in (1.02 m)

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: 
D. SHEPHERD (DE # 02)

DATE: 09.07.21
CERT. NO.: SH96-88
ISSUE NO.: 3

A	NEW ISSUE	RF	09.07.21
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED		DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9464	SHEET 1 OF 3
APPROVED		TITLE	SCALE
DE APPR.		SKIDTUBE TUNING KIT	NTS
DATE	09.07.21	COPYRIGHT © 2009 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

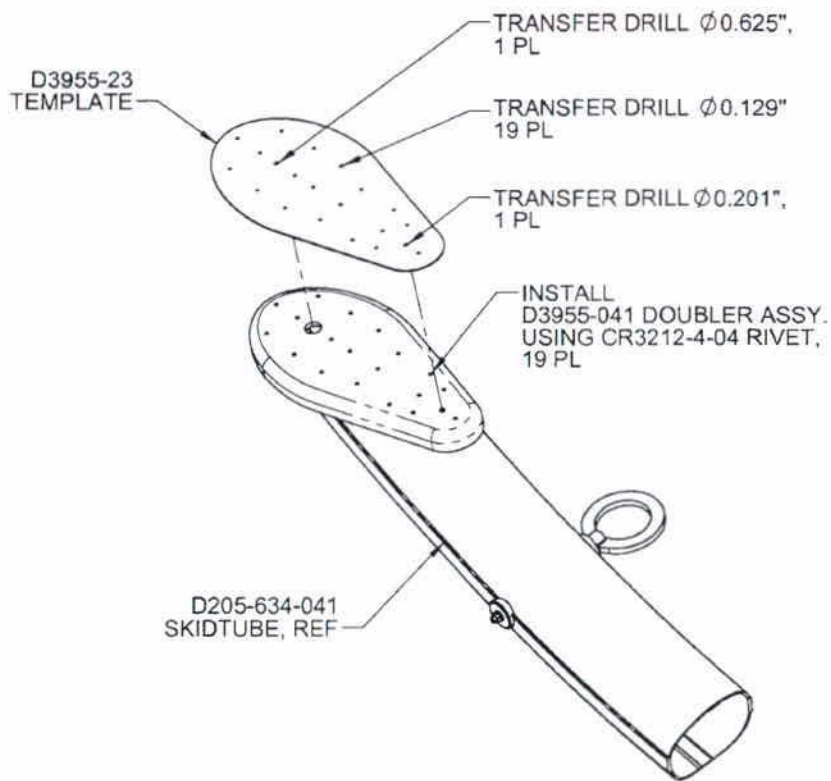


Figure 1

51549

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: 
D. SHEPHERD (DE # 02)

DATE: 09.07.21
CERT. NO.: SH96-88
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DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		DSI 9464	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		SKIDTUBE TUNING KIT	NTS
DATE	09.07.21	COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

Part List

Qty -011	Part Number	Description	Weight
X	DSI 9464-011	SKIDTUBE TUNING KIT	N/A
2	D3955-041	DOUBLER ASSEMBLY	0.25 lb/ 0.11 kg
2	D3955-3	COVER PLATE	0.64 lb/ 0.29 kg
2	D3955-5	0.063" THICK PLATE	0.64 lb/ 0.29 kg
6	D3955-7	0.125" THICK PLATE	1.28 lb/ 0.58 kg
2	D3955-21	GASKET	0.08 lb/ 0.04 kg
2	D3955-23	TEMPLATE	N/A
38	CR3212-4-04	RIVET	N/A
4	AN3-5A	BOLT	N/A
4	AN3-6A	BOLT	N/A
4	AN3-7A	BOLT	N/A
4	AN3-10A	BOLT	N/A
6	NAS1149D0332J	WASHER	N/A
2	MS21042L3	NUT (OR MS21042-3)	N/A

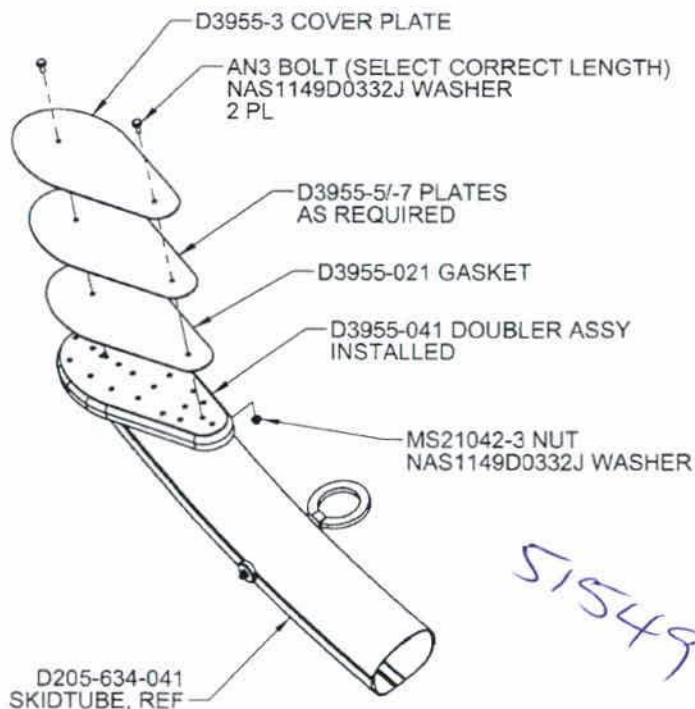


Figure 2

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: *[Signature]*
D. SHEPHERD (DE # 02)

DATE: 09.07.21
CERT. NO.: SH96-88
ISSUE NO.: 3

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		DSI 9464	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		SKIDTUBE TUNING KIT	NTS
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Part List

Qty -011	Part Number	Description	Weight
X	DSI 9464-011	SKIDTUBE TUNING KIT	N/A
2	D3955-041	DOUBLER ASSEMBLY	0.25 lb/ 0.11 kg
2	D3955-3	COVER PLATE	0.64 lb/ 0.29 kg
2	D3955-5	0.063" THICK PLATE	0.64 lb/ 0.29 kg
6	D3955-7	0.125" THICK PLATE	1.28 lb/ 0.58 kg
2	D3955-21	GASKET	0.08 lb/ 0.04 kg
2	D3955-23	TEMPLATE	N/A
38	CR3212-4-04	RIVET	N/A
4	AN3-5A	BOLT	N/A
4	AN3-6A	BOLT	N/A
4	AN3-7A	BOLT	N/A
4	AN3-10A	BOLT	N/A
6	NAS1149D0332J	WASHER	N/A
2	MS21042L3	NUT (OR MS21042-3)	N/A

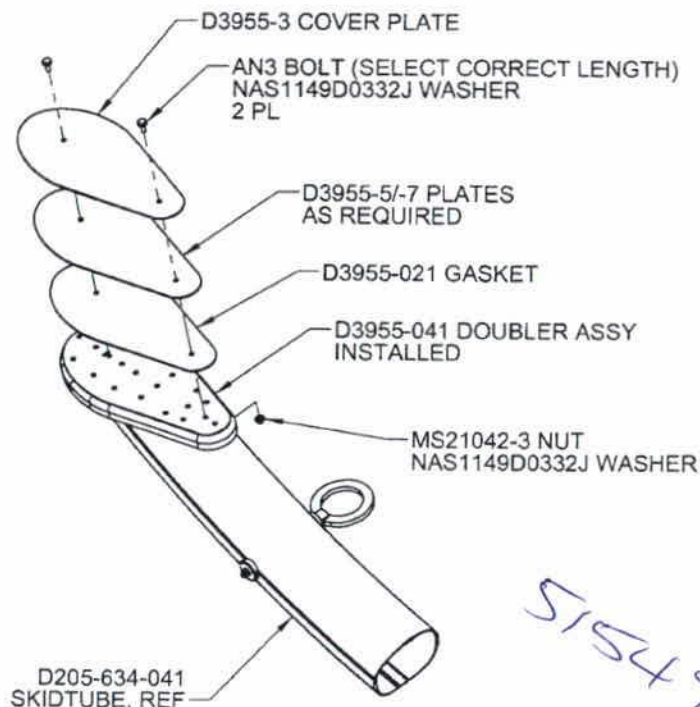


Figure 2

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-Q-01

APPROVED

BY: *[Signature]*
D. SHEPHERD (DE # 02)

DATE: 09.07.21
CERT. NO.: SH96-88
ISSUE NO.: 3

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DRAWN	RF		
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		DSI 9464	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		SKIDTUBE TUNING KIT	NTS
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